



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D2438
Job Sheet 179677



Part No: D2438

Job Qty: 40 ea

Part Name: Clamp



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 6/21/18

Job Tracking No:

Due Date: 7/18/18

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG D2727 REV A1, D2438 REV C IPP: E 05.06.28 Bending removed KJ/JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	40 Ea		7/18/18	0.00	0.00	Start Up Waterjet		SC 18/07/18
100	Waterjet	40 pcs		7/18/18	0.00	1.41	Waterjet1		38 18/07/18
120	QC	40 pcs		7/18/18	0.00	0.00	QC8		38 9-89
130	Small Fab	40 pcs		7/18/18	0.01	1.38	Small Fab		38 9-89
140	QC	40 pcs		7/18/18	0.00	0.00	QC5		38 18-08-13
150	Packaging	40 pcs		7/18/18	0.00	0.00	Packaging3		38 9-89
160	QC21-SA	40 Ea		7/18/18	0.00	0.00	QC21		AUG 15 2018

Part Op 100 - Cut as per dwg D2438 prog rev: C dwg rev: C

Descriptions: 120 - (6.786" center to center)

130 - 1- Use DT9713 clamp holder to hold clamp in place when forming 2- Bend as per dwg used DT9709

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M304S16GA	304/316 Sheet .063	1.6000 sf (.04 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M304S16GA	2	235	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Clamp	0.750inches $\pm$ 0.010	0.760 0.740	0,750	
2	Clamp	6.786inches $\pm$ 0.010	6.796 6.776	6,784	
3	Clamp	7.586inches $\pm$ 0.010	7.596 7.576	7,582	
4	Clamp	0.063inches $\pm$ 0.010	0.073 0.053	0,058	
5	Clamp	0.257inches $\pm$ 0.006 - 0.001	0.263 0.256	0,259	

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____ Date : _____ Ste _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐							
Description Work Order		DART AEROSPACE Part: D2438 Job No: 179677 Serial No/Batch: S089860 Revision: _____ Inspector: _____ Exp Date: _____ Instructions: _____ Date: 07/08/18 DART AEROSPACE Container No: S089860 1270 Aberdeen Street Haverhill, MA 01830 CANADA TEL: 1 519 832-8200 Email: sales@dartaero.com www.dartaerospace.com							
		MRB (QSI042) Approval _____ Completed By _____ Lead hand / Supervisor Approval Verification _____ QC / QA Coordinator Approval _____							
Root Cause <table style="width:100%;"> <tr> <td style="width:50%;"> Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ </td> <td style="width:50%;"> No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐ </td> </tr> </table>		Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	<table style="width:100%;"> <tr> <td style="width:33%;"> Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ </td> <td style="width:33%;"> Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ </td> <td style="width:33%;"> Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ </td> </tr> </table>			Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐
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